

Work Order ID 61520

Monday, August 30, 2010 9:20:10 AM



Page 1

Item ID: D3516-041

Accept



Setup Start



Revision ID:

Item Name: Basket Base Assembly (A119)

Stop



Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: *10-8-30*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3516

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Cut rib D3516-1 as per dwg D3516□2-Cut rib D3516-3 as per dwg D3516□3-Cut rib D3516-5 as per dwg D3516□4-Cut rib D3516-7 as per dwg D3516□5-Cut rib D3516-15 as per dwg D3516□6-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

Pl 11.08.19

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld assembly as per dwg D3516

Pl 11.08.19

RMB 11/08/07

120

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

BE 11.09.07

1.1 11/09/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Cut expanded metal for base as per dwg D3516 □2-Cut expanded metal for base ends as per dwg D3516 □3-Weld expanded metal to base as per dwg D3516

CP 11.09.07

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE
11.09.07

1 0

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Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Powder Coating

Memo

IST COAT: ☐ START TIME: _____ ☐ OVEN
TEMPERATURE: 400°F ☐ FINISH TIME: _____
☐ ***** 2nd coat if
necessary ***** ☐ 2ND COAT: ☐ START TIME: _____
☐ OVEN TEMPERATURE: _____

0.00

180

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

IX ~~✓~~ M/11/09/08

M17745

2-45

1 BL 11-9-12

W/O:		WORK ORDER CHANGES					
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Page 4

Monday, August 30, 2010 9:20:10 AM

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Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly (A119)

Start Date: 8/30/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

w/o

61518

0.00

Packaging

JS 11/09/12 @

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/13MF
11-09-12

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, August 30, 2010 9:20:14 AM

Page 1

Work Order ID: 61520

Parent Item: D3516-041

Parent Item Name: Basket Base Assembly (A119)





Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. A 06.05.31 Preliminary EC
IPP rev. b 06.07.27 updated EC
IPP Rev:C 08-02-25 ECN 1138P DD verified by: LL
IPP Rev:D 08-03-18 ecn 1136 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2232-3  Basket Hinge		Manufactured	No			100	Each	6.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>61182</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2327-3  Spacer Bushing		Manufactured	No			100	Each	31.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div></div> </div> <div> <div>Loc Qty</div> <div>31</div> <div>1</div> <div>1</div> <div>9</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
D2581  Mounting Bracket		Manufactured	No			100	Each	45.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div></div> </div> <div> <div>Loc Qty</div> <div>45</div> <div>10</div> <div>35</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3166-1  Basket Hoop		Manufactured	No			100	Each	0.0000	4	4			

PL 11.08.19
B72929 → ①
B71796 → ①

PL 11.08.19
B71971 → ②

PL 11.08.19
B70766 → ①
B69258 → ①

PL 11.08.19
B70924 → ④

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 2

Work Order ID: 61520

Parent Item: D3516-041

Parent Item Name: Basket Base Assembly (A119)

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

D3442-1 Manufactured No

100 Each

20.0000

2

2



Shim

Location

Loc Qty

Loc Code

WA

20

60177

8

61181

12

371224 → (2)

D3516-11 Manufactured No

100 Each

14.0000

6

6



Clevis

Location

Loc Qty

Loc Code

WA

14

51122

14

(6)

D3516-13 Manufactured No

100 Each

63.0000

4

4



Clevis

Location

Loc Qty

Loc Code

WA

63

45564

20

45565

43

(4)

D3725-1 Manufactured No

100 Each

18.0000

2

2



Hoop

Location

Loc Qty

Loc Code

ST086

18

50939

7

51118

11

(2)

Monday, August 30, 2010 9:20:15 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Monday, August 30, 2010 9:20:15 AM

Page 3

Work Order ID: 61520

Parent Item: D3516-041

Parent Item Name: Basket Base Assembly (A119)

Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 1.00

Required Qty: 1.00

M304EX0.75-16F

Purchased

No

100

sf

811.5923

60

60



Expanded Metal Flat SS

Location

Loc Qty

Loc Code

MAT

811.592333

114809

139.403243

114853

11.80059

115012

395.1315

115067

13.0125

115171

7.3394

115401

244.9051



Pl 11-08-19
CK
~~M118181~~

60

M304TS0.750W.065

Purchased

No

140

f

581.5953

50.65

53.31579



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

538.3049

112398

0

114482

1.4628

115494

536.8421

WA

43.290385

114520

11.363385

115274

31.927



Pl 11-08-19
M118181 → 53.3157

Monday, August 30, 2010 9:20:15 AM

Shop Packet Print

Page 3

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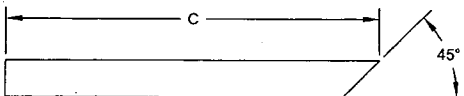
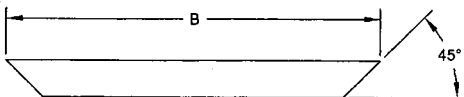
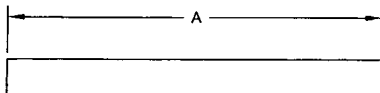
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PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	—	102.00	—	RIB
D3516-3	2	—	—	2.70	RIB
D3516-5	8	26.75	—	—	RIB
D3516-7	3	45.50	—	—	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



D3516-041 BASKET BASE ASSEMBLY NOTES:

1) MATERIAL:

FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)

MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)

2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 75 lbs

8) WELDING: PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61520
BS10-8-30

RELEASED
08-22-17

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.02.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3516 SHEET 1 OF 4
TITLE SCALE
BASKET BASE ASSEMBLY NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

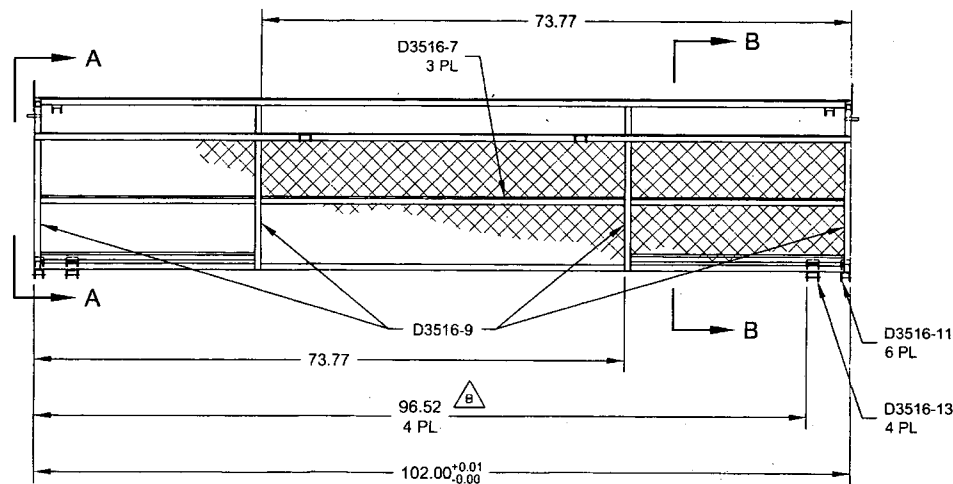
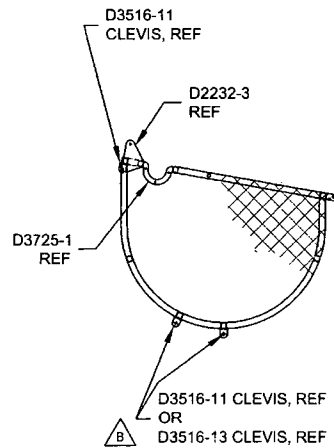
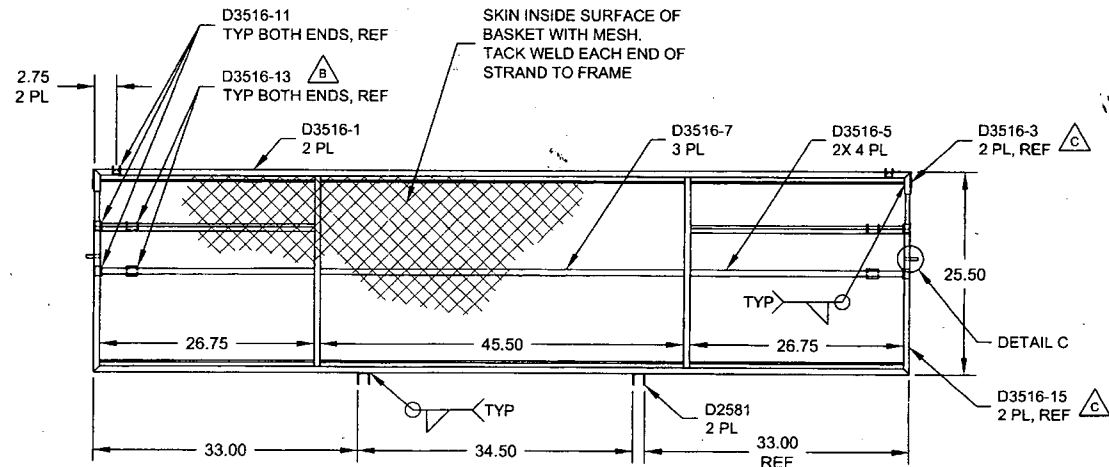
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3/4
1004
x 28 5/8



D3516-041 BASKET BASE ASSEMBLY

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 2 OF 4
APPROVED		TITLE	SCALE
OE APPR.		BASKET BASE ASSEMBLY (A119)	NTS
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W64152d

Not as n/a

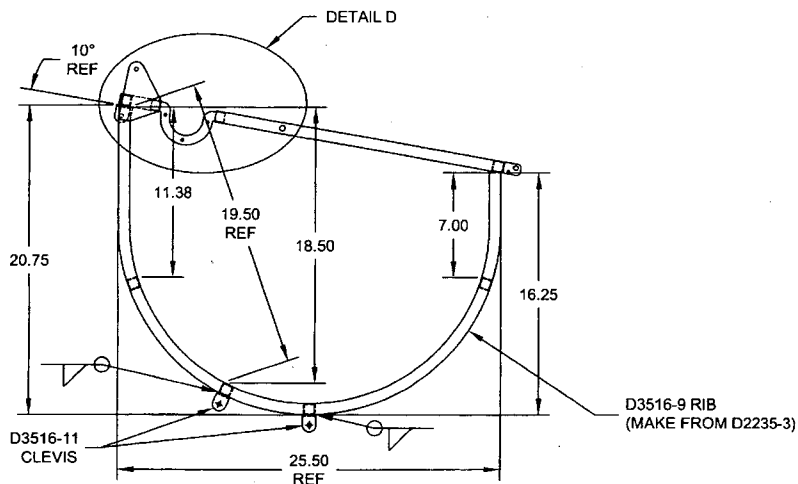
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

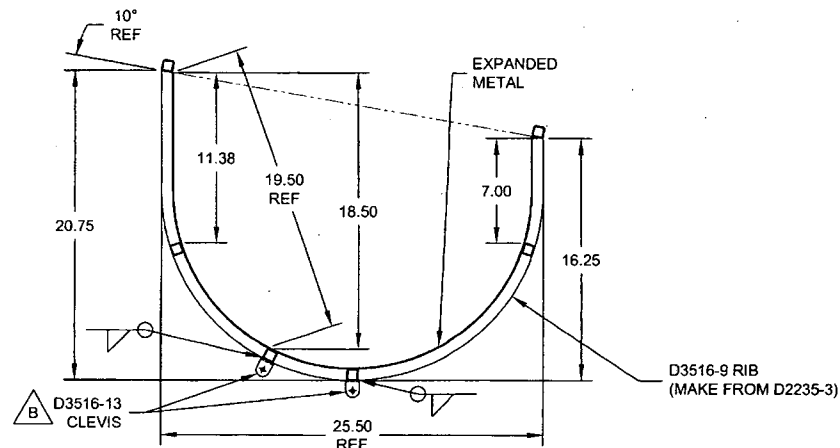
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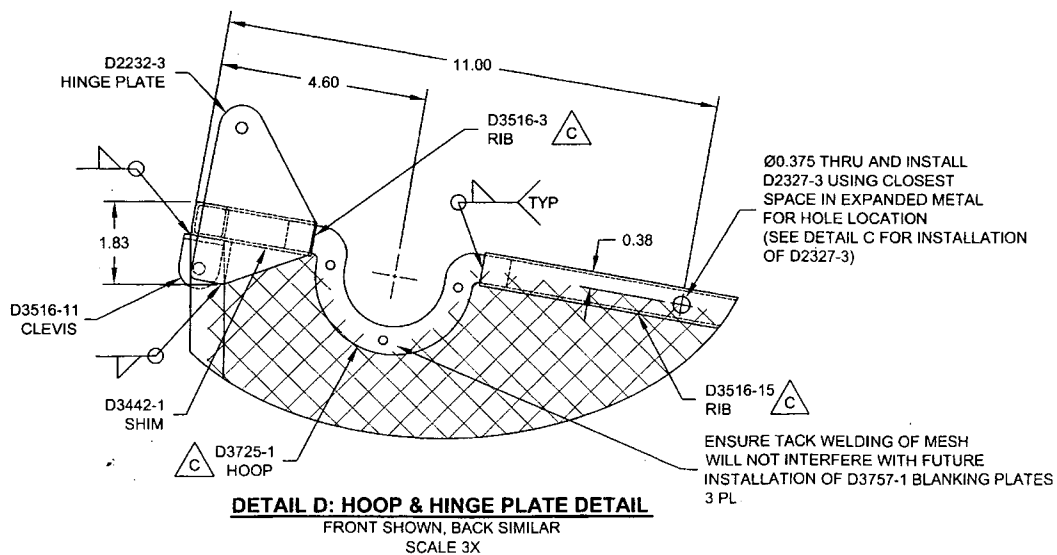
NOTE: Date & initial all entries



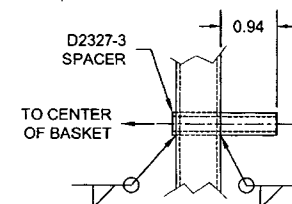
SECTION A-A: END RIB DETAIL
(MESH NOT SHOWN FOR CLARITY)
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X



DETAIL C: SPACER INSTALLATION
SCALE 4X

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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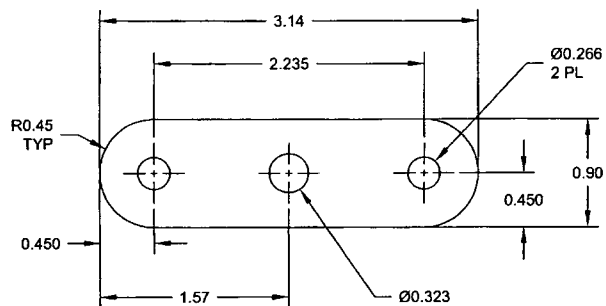
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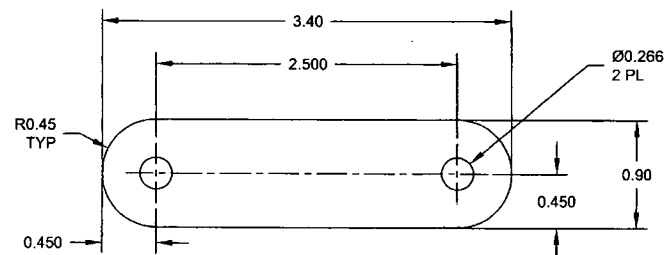
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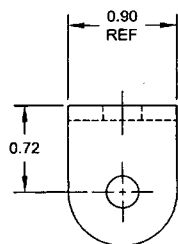
NOTE: Date & initial all entries



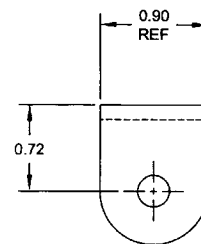
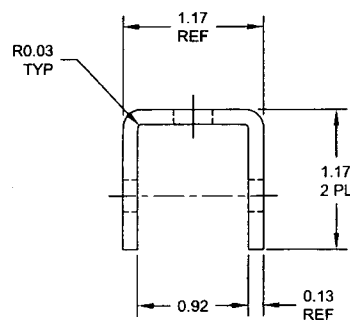
1 D3516-11F CLEVIS FLAT PATTERN



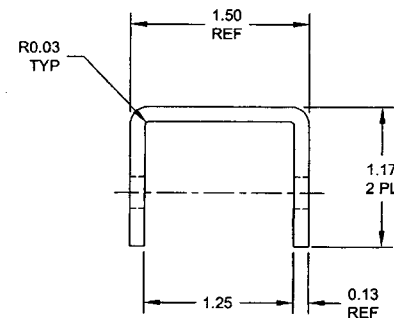
1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)



D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119) NTS	
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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w/0 4520

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries